

ASAP for budget

Dart Aerospace Ltd.

Date: Tuesday, 7/1/2008 2:35:01 PM
User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STRUT |
| Job Number : 40195 | |
| Estimate Number : 10219 | |
| P.O. Number : | Part Number : D219923 |
| This Issue : 7/1/2008 S.O. No. : | Drawing Number : D2199 REV. E1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL / MED FAB | Drawing Revision : E1 |
| Previous Run : 37849 | Material : |
| Written By : | Due Date : 7/15/2008 Qty: 6 Um: Each |
| Checked & Approved By : <u>08.07.01</u> | |
| Comment : Est:D 02.06.10 Rem polish & add finish NG/CC | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 2.3100 f(s)/Unit Total: 11.5500 f(s) 15.000

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M108498

SB 08/07/21 (6)

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/07/21 (6)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

08/07/21 (6)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/21 (6)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 7:50 OF

OVEN TEMPERATURE: 400

FINISH TIME: 8:20

MIL 08/07/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40195

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/07/22 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57247 PC 8/7/22 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22

Job Completion



MF 08-07-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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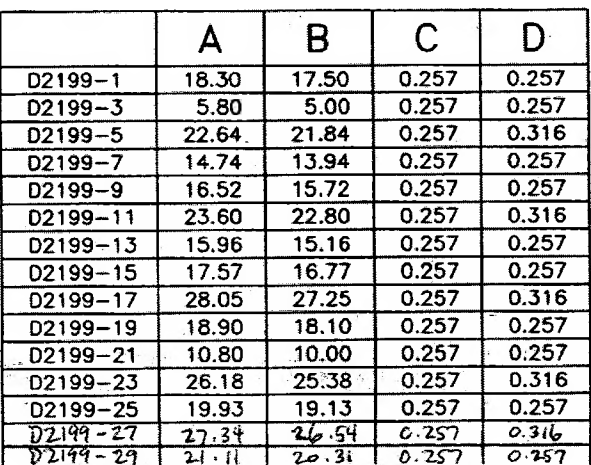
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____


| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

RELEASED
48.05.05 KE



B
 B
 B
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 # 00.10.13
 CP 00.10.13

3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3 

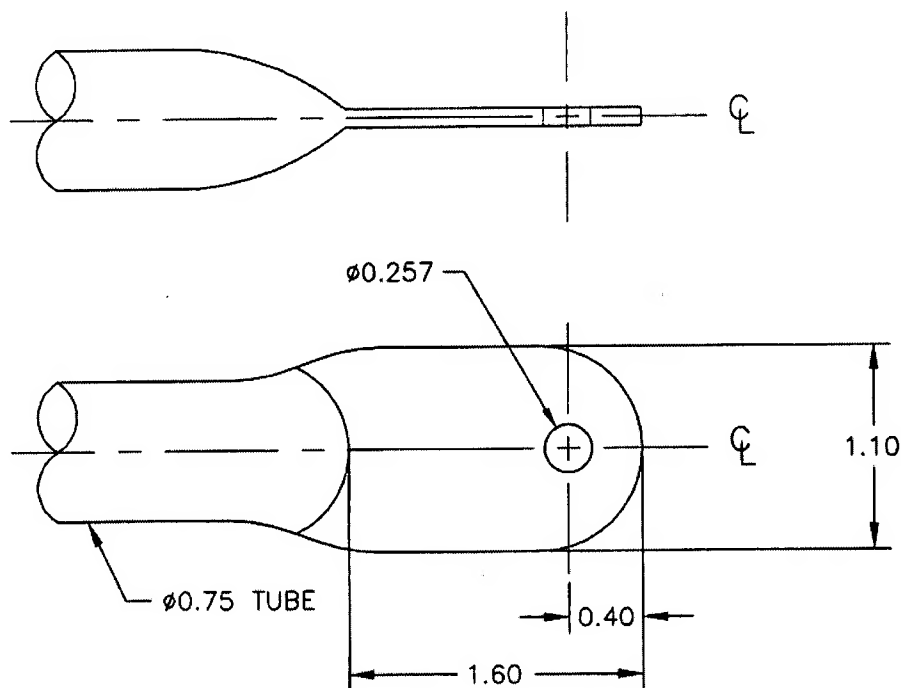
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WORK ORDER
NO. 40145



| | | | |
|------------------|------------------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED MJB | APPROVED [Signature] | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | TITLE PUNCH DT8117 SPEC CONTROL | | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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